

Work Order ID 85372

June-07-12 9:18:38 AM

85372

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Item ID: D412-664-301

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap Assembly Bumper

Stop ***NS2***

Start Date: 07/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 21/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/07* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D212-664	G

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-664-301 chg001

Scrub 27
JB

JA Car MLJ 12-6-27
(10)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

10

12/06/26 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Scrub 27

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-664-301

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cap Assembly Bumper

Stop

NS2

Start Date: 07/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 21/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-664-301

Location: 100

PPP Rev: _____

(100)

Sp
12-6-27

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/28 JH

ME

12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85372

85372

Parent Item: D412-664-301

D412-664-301

Parent Item Name: Cap Assembly Bumper


Start Date: 07/06/2012

Required Date: 21/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.11.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4381-1		Manufactured	No			110	Each	39.0000		20			

D4381-1

X-tube Strap Bumper

**

29 12/06/26

Location

Loc Qty

Loc Code

ST109

39

69506

39

69506

SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.4 214B/B-1 CROSSTUBES

The following crosstube installations are available from Dart for the 214B/B-1 model aircraft:

QTY -101B	QTY -107B	QTY -201B	QTY -207B	Part Number	Description	Equivalent 204/205/212 Kit
X				D212-664-101B	CROSSTUBE INSTALLATION, 214 HIGH FWD	D212-664-101
	X			D212-664-107B	CROSSTUBE INSTALLATION, 214 STANDARD FWD	D212-664-107
		X		D212-664-201B	CROSSTUBE INSTALLATION, 214 HIGH AFT	D212-664-201
			X	D212-664-207B	CROSSTUBE INSTALLATION, 214 STANDARD AFT	D212-664-207
1				D212-664-141B	CROSSTUBE ASSEMBLY, 214 HIGH FWD	D212-664-141
	1			D212-664-147B	CROSSTUBE ASSEMBLY, 214 STD FWD	D212-664-147
		1		D212-664-241B	CROSSTUBE ASSEMBLY, 214 HIGH AFT	D212-664-241
			1	D212-664-247B	CROSSTUBE ASSEMBLY, 214 STD FWD	D212-664-247

The D212-664-101B/-107B/-201B/-207B are the same as the equivalent crosstubes listed in the table above. However, the spacing of the supports is narrower to accommodate 214 model aircraft, as illustrated in Figure 3-10 of these instructions. The kits are otherwise installed, maintained, and have identical replacement parts lists per their equivalent crosstube. All statements in FMS-D214-664 that apply to the D212-664-101/-107/-201/-207 crosstubes are also applicable to D212-664-101B/-107B/-201B/-207B crosstubes.

Note that Dart D212-664-101/-107/-201/-207 crosstubes may also be installed on 214B/B-1 model aircraft. To install on 214 aircraft, the supports on the -101/-107/-201/-207 crosstubes must be repositioned per the support removal/installation instructions of ICA-D212-664 (section 32.3 and section 32.4 of rev. 8 or later revision) using 13.75" spacing (REF).

Likewise, Dart D212-664-101B/-107B/-201B/-207B may be installed on 204/205/210/412/UH-1 model aircraft. To install on 204/205/210/412/UH-1 aircraft, the supports on the -101B/-107B/-201B/-207B crosstubes must be repositioned per the support removal/installation instructions of ICA-D212-664 (section 32.3 and section 32.4 of rev. 8 or later revision) using 14.00" spacing (REF).

5.5 ADDITIONAL KITS

Item	QTY -301	QTY -303	Part Number	Description
	X		D412-664-301	CAP ASSEMBLY BUMPER KIT
		X	D412-664-303	SWITCH PROVISIONS KIT
18		1	D3189-3	CHAFING SHIELD
60	2		D4381-1	BUMPER
19		2	MS21920-24	CLAMP (OR MS21920-23)